

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003126**Date Inspected:** 24-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

New Tower Bay 1

The Caltrans QA Inspector randomly observed the machine Submerged Arc Welding (SAW) of fill passes on Weld Nos. NSD1-SA159D/J-4A, Skin Plate Face "A". This is a complete joint penetration (CJP) groove weld. The welding was performed in the flat groove (1G) welding position by welding operator; Xu Yan (I. D. No. 052917). Welding Procedure Specification (WPS) WPS-B-T-2221-B-U3c-S was used. Certified Welding Inspector (CWI), Xu Le Feng (CWI No. 07031411), was present during the welding, as was ABF QA Inspector, You Yuan mao. The Caltrans QA Inspector verified the qualifications of the welding operators, and that the electrode/flux classification, diameter of electrode, amperage, voltage, travel speed, and preheat/interpass temperatures were within the specified ranges on the applicable WPS.

The Caltrans QA Inspector also randomly observed that no milling or flame cutting was done during this shift.

New Tower Bay 2

The Caltrans QA Inspector randomly observed the milling of the weld bevel on miscellaneous tower parts.

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All above observations appeared to meet the requirements of the job specifications.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Jobs,Kenneth

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer